

HIGH PRECISION MACHINE PARTS

TO YOUR SPECIFICATIONS

PROCESS NOTES

JOB NO. 2594 PART NUMBER 1862 REV. 1

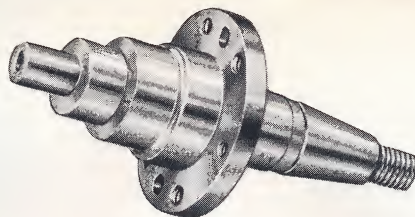
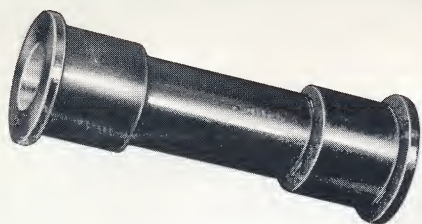
MATERIAL MXB-1113 BY JN

DESCRIPTION (See individual operation sheet)

OPERATION NUMBER	DESCRIPTION
10	Blank per drawing 1861-1
20	Inspect per drawing 1861-1
30	Centerless grind shaft to .321/.3195
40	#2 Center drill and #44 Drill at "F" --- HARDINGE D.S.M. 59
50	#2 Center drill and #47 Drill at opposite end --- HARDINGE D.S.M. 59
60	Turn 25/32" X .010 recess in face "D" --- HARDINGE D.V. 59
70	Turn grind relief 3/8" X .010 in face "C" --- HARDINGE D.V. 59
80	Mill .468 star clearance --- HARDINGE S.A. MILL -- INDEX HEAD
90	Drill pin plug hole #107 -- DRILL PRESS
100	Chamfer plug hole -- Cam Department
110	Drill 2 holes - #50 Drill - in diameter "B" -- #108 DOUBLE DRILL MILL
120	Drill, Counterbore --- #108 DOUBLE DRILL MILL
130	Cut left and right
140	#44 Drill at face
150	Heat Treat Per S.
160	Inspect heat t
170	Anneal flange
180	Inspect plug hole
190	Color blast and Black o.
200	Lap centers, both ends
210	Green grind diameters "A" and "E" .3136 ± .0001
220	Green grind diameter "B" .928 ± .0002 --- .0003 TIR MAX -- B & S CYL.
	Grind faces "F" and "D" --- LAVEZZI FACE GRINDER
	Grind faces "B" and "D" --- .9270/.9268 16 RMS .0001 TIR -- B & S CYL.
	Grind faces "B" and "D" --- .3126/.3124 16 RMS .0001 TIR -- B & S CYL.

by

LaVeZZi



LA VEZZI MACHINE WORKS—specialists in the manufacture of small machine parts involving considerable secondary machining to close tolerances and fine finishes.

THIS IS A SPECIALIZED SERVICE to industry for the benefit of the original equipment manufacturer who needs a time-proven source for difficult machine parts in quantity,—and to the designer or the model maker who is in need of parts made in small quantity to his own design, consistently made correctly.

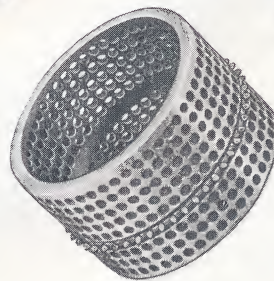
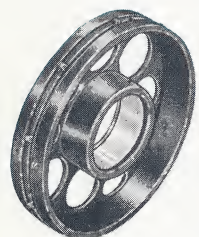
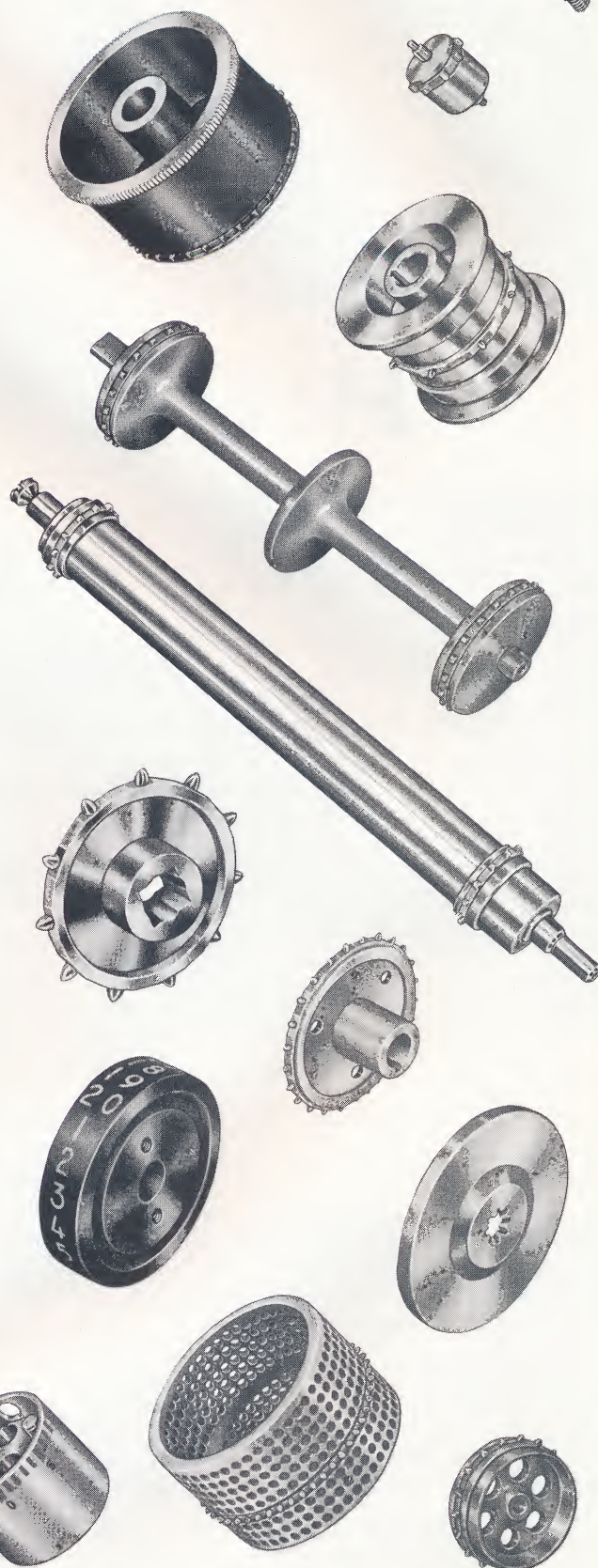
This service includes the critical machining operations of—

BLANKING on Super Precision Automatics and on Turret Lathes, of parts from bar stock up to 3" in diameter, holding tolerances and surface finishes not common in blanking operations. This equipment has been specially selected for its efficiency in multiple operation work to hold cost at a low level.

TURNING to close dimensions and complex forms, on high precision bench lathes, chucking lathes and turning-facing-boring machines. Proper tooling is an important part of this operation, permitting very close limits on laterals, diameters, concentricity and finish.

BORING, BROACHING, HONING, of all hole sizes to all shapes, including internal splines, keyways, etc., and to the tolerances required on diameter, parallelism, and concentricity.

DRILLING, on automatic equipment to close limits on location, registration, size, depth, etc. This includes drilling and tapping of a number of holes around a piece, with a minimum of set-up and limited fixturing.

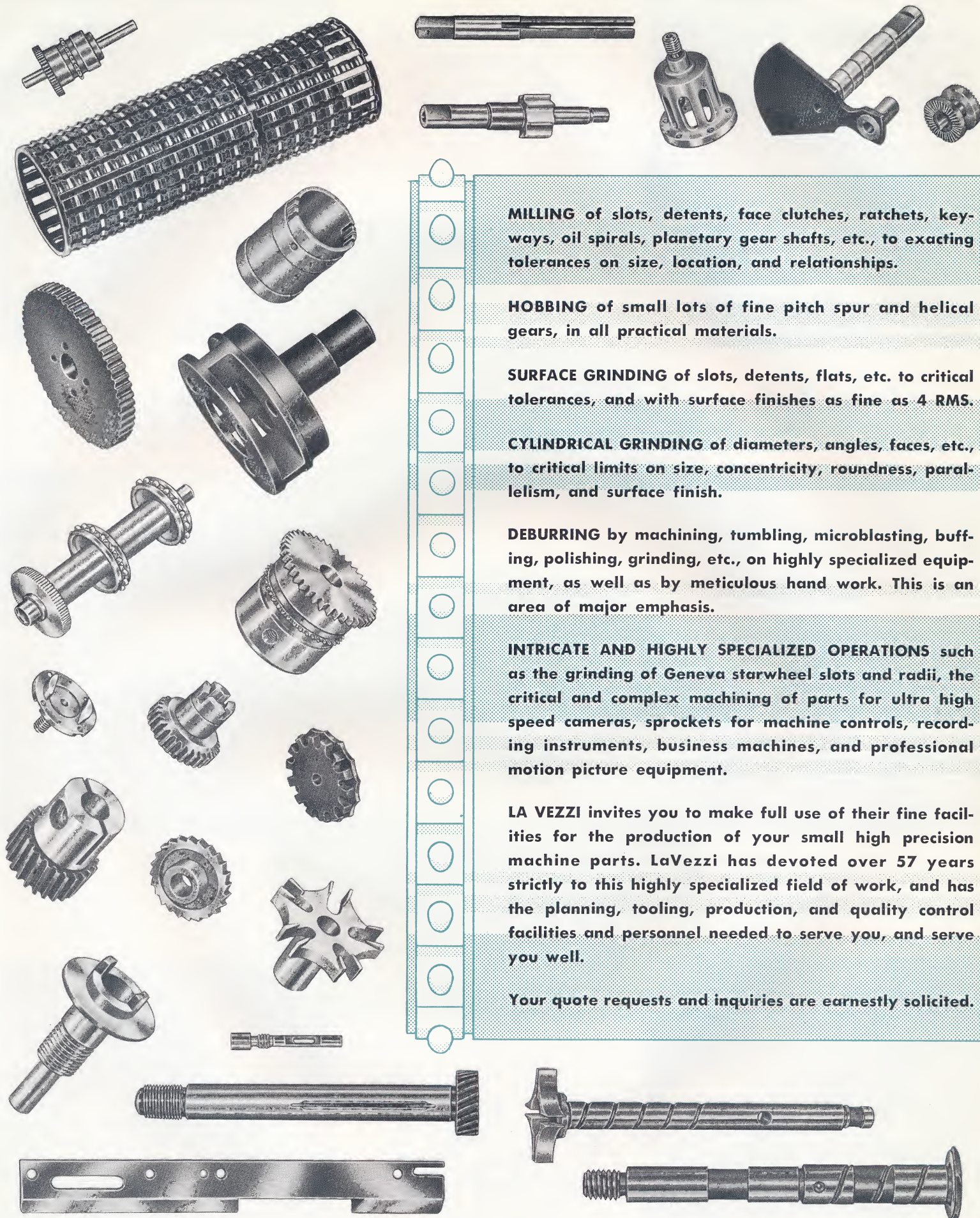


LA VEZZI MACHINE WORKS

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BROCHURE B-58



MILLING of slots, detents, face clutches, ratchets, keyways, oil spirals, planetary gear shafts, etc., to exacting tolerances on size, location, and relationships.

HOBGING of small lots of fine pitch spur and helical gears, in all practical materials.

SURFACE GRINDING of slots, detents, flats, etc. to critical tolerances, and with surface finishes as fine as 4 RMS.

CYLINDRICAL GRINDING of diameters, angles, faces, etc., to critical limits on size, concentricity, roundness, parallelism, and surface finish.

DEBURRING by machining, tumbling, microblasting, buffing, polishing, grinding, etc., on highly specialized equipment, as well as by meticulous hand work. This is an area of major emphasis.

INTRICATE AND HIGHLY SPECIALIZED OPERATIONS such as the grinding of Geneva starwheel slots and radii, the critical and complex machining of parts for ultra high speed cameras, sprockets for machine controls, recording instruments, business machines, and professional motion picture equipment.

LA VEZZI invites you to make full use of their fine facilities for the production of your small high precision machine parts. LaVezzi has devoted over 57 years strictly to this highly specialized field of work, and has the planning, tooling, production, and quality control facilities and personnel needed to serve you, and serve you well.

Your quote requests and inquiries are earnestly solicited.

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A SMALL BUSINESS CONCERN



LaVezzi

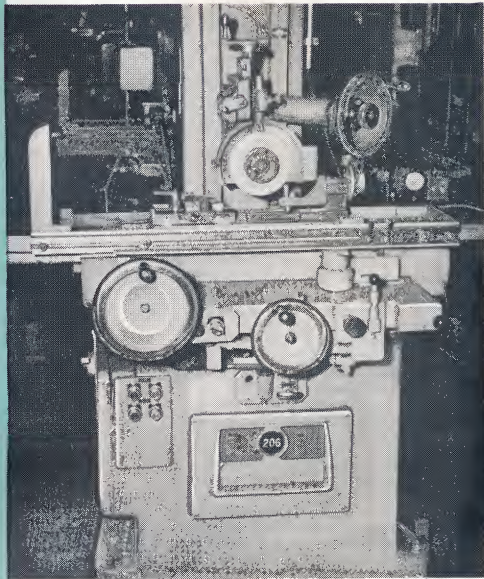
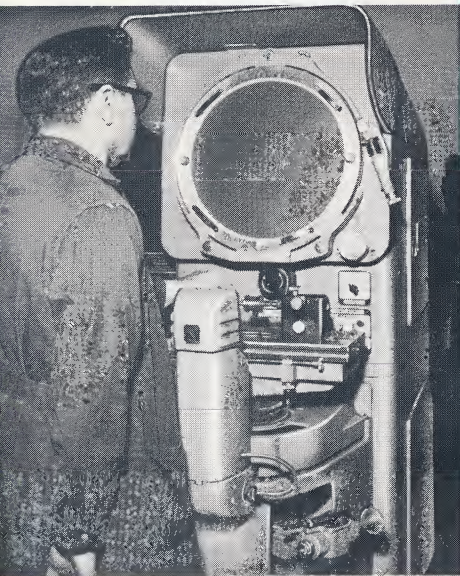


YOUR DRAWING AND PURCHASE ORDER SPECS are the masters in our production, and to support this with work which meets all your specifications (and anticipates some additional requirements to improve the item) our processing engineers use their many years of experience in this unique field of work to plan each step so that operations will be combined, automatic equipment will be used, and cost held at the lowest point, while at the same time meeting the very closest quality requirements.

Excellent planning, clever and efficient tool design, machine tools specially selected or specially built for this class of work, and fine quality control instruments, all in the hands of experts, guarantee finished parts you are sure to enjoy receiving, parts that will get enthusiastic reception from your buyers, engineers, designers, quality control and assembly staff.

Standard machine tools such as the Gisholt #5 turret lathes, and the new Hardinge ASM5C Super Precision Automatics, the Sunnen Hones, and the Gallmeyer and Livingston Surface Grinders, are supplemented by many machines built specifically for our class of production, and the inspection department is well equipped with latest facilities such as the Jones and Lamson Optical comparators. A complete list of our production, tooling and inspection facilities is available upon request.

We are anxious to be of service on your requirements for these small high precision machine parts and invite your quote requests and inquiries. They will be handled promptly and carefully we assure you, and we are confident of our ability to serve you well.



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